Work Order November-27-12				*938	885*						Page 1
	02933-2	ı		Accept	*N900	140	100	* s	etup Start	*N	S1*
Revision ID: Item Name: S	Saddle RH In,	206							Stop	*N	S2*
Required Date: 1	12/03/12 12/14/12	Start Qty: 6.00 Req'd Qty: 6.00	*6* *6*	i de	Cust Item II Customer:) :					
Reférence:						<u> </u>	-	R	tun Start	*N1	D1*
Approvals:	Process Plan	n:ML5	Date: 12-11-29	Tooling:	Da	te:			Stop	IVI	T I
1 - 1 - 1 - 1 - 1 - 1 - 1 - 1 - 1 - 1 -	QC:	· · · · · · · · · · · · · · · · · · ·	Date:	SPC (Y/N):	Da	te:			ьюр	*N	R2*
Sequence ID/ Work Center ID		Operation Description		Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revi	ision Nbr	·	ν		I					
D2933	Rev	C			€T	1				•	
100				0.00		1	· · · · · · · · · · · · · · · · · · ·	•	t t	.1.	
100 HAAS I		HAAS CNC VERTICA	AL MACHINING #1	0.00	ml 13/03/	29	į	6			
HAAS CNC vertical I	machine #1	number ar inspect as	art number and batch number e programmed correctly.2-Ma per dwg D2933 & attached D nd visually inspect as per	achine Step No 1 of Foli	o and visually					•	
110			•	0.00		į					
110		CONVENTIONAL MI	LLING MACHINE		OX 13/0	3/20	3	/	_6		
Mill Conv	*	Memo		0.00			,	e			
Conventional Milling	Machine	Machine R	Keyway and inspect per attach	ed dimension sheet	•	-					
1	·			to a sign	: :			٠.			
120		QC1- Inspect dimension	ons to dimension sheet	0.00	M 13/03	129					
120	• •	Memo		0.00	· ·	ļ		le	B		
Quality Control		• •	:		and the second second	ļ					•

											DQA:	Date:	
NCR:	Yes / I	No				WORK ORDER NON-C	ONF	ORN	MANCE / UPDATE				
				1							QA Closed:	Date:	
Work Orde	er·			ĺ		DISPOSITION			AG	AINST DE	PARTMENT	PROCESS	
Part N	No			,		Rework Scrap Use-as-is Work Order Update	T	N herm	Machining Sma	stube all Fab ishing posite		Water Jet d. Eng. Coor. re/Packaging Supplier	Engineering Quality Other
Root				į	Descri	ption of work order update	Initi	ial	Action		Sign &		
Cause	Da	te S	Step	Qty	C	or Non-conformance	Chief	Eng	Description		Date	Verification	QC Inspector
Doc/Data Equip/Tooling Operator, Material Setup Other Process Supplier													
Training Unapproved				İ									
·			. <u>-</u>	!		F/	AULT C	ATEC	ORY				
Landi	ng Gear		-			General					1		
	Crack Crush Cuffs Heat	e Not Cos s ed/Crin Treat	mped.	i i	D/S	Bend BOM/Route Broken/Damaged Burrs Contamination Countersink	Ins Ins Ma	rdwar pection truction ainter slabel	on Incomplete ons Incomplete/Unclear nance		Ovalized Over/Under Part Incorred Part Lost/Mi Part Moved Positioned V	ct ssing vrong	Pressure/Forced Temperature/Cure Weld Wrong Stock Pulled
		ction St es in Bei	-	ube		Cut Too Short Drill Holes	⊢	sread fset			Power Loss/	Surge	Other
1						•							

Out of Calibration

Out of Sequence

Outside Dimensions

Turning Sequence

Wave/Twist in Tube

Torque Waves in Extrusion

Drawing

Finish

Folio

H:/FORMS/Quality Assurance\approved QA/NCRWO Rev G

Work Ord November-27-12				*938	85*	l F				-	Page 2
Item ID: Revision ID: Item Name: Start Date: Required Date: Reference:	D2933-2 Saddle RH In 12/03/12 12/14/12	n, 206 Start Qty: 6.00 Req'd Qty: 6.00	*6* *6*	Accept	*N9000 Cust Item II Customer:	, , ,	100)*	Setup Star Stop	14.	<i>-</i>
Approvals:		an:		Tooling:	Da Da	!]	Run Star Stop	"IN F	
Sequence ID/ Work Center II 130 *130* QC Quality Control	D ·	Operation Description QC8- Inspect parts - second	ond check	Set Up/ Run Hours 0.00	Tool ID	Tool#	Plan Code	Accept Qty	Reject Qty		Insp. Stamp
*140 *140 HandFinish Hand Finishing		Chemical Conversion Co Memo	oat per QSI005 4.1	0.00				6	H	13.9-	2
*150 *150* Powdercoat Powder Coating		White Gloss(Ref:4.3.5.1 Memo START TIM 3 2 3 1	IE: FINISH TIME:	0.00 0.00 OVEN TEMPERATURE 0.00	:			6X)	B_M,	£ 13	<u>/04/</u> 0

W124245

									DQA.	Date.	
NCR: Y	es / No		ļ	WORK ORDER NO	N-COI	NFORI	MANCE / UPDATE		QA Closed:	Date:	
Mank Onda		_		DISPOSITION			AGAINST	DE	PARTMENT		
Work Orde Part N NCR N	lo			Rework Scrap Use-as-is Work Order Update		Thern	Skid-tube Crosstube Machining Small Fab noforming Finishing Large Fab Composite		4	Water Jet d. Eng. Coor. e/Packaging Supplier	Engineering Quality Other
Root				Description of work order update	e I	nitial	Action		Sign &		
Cause	Date	Step	Qty	or Non-conformance	Ch	ief Eng	Description		Date	Verification	QC Inspector
Doc/Data											
Equip/Tooling				·							·
Operator				\$							
Material											
Setup											
Other											
Process											
Supplier			, ,								
Training											
Unapproved											
					FAUL	T CATE	GORY				
Landin	ng Gear		İ	General	_				-		7
Ĺ	Bending			Bend		Grain		L	Ovalized		Pressure/Forced
. [Centre No	ot Concei	ntric to	O/S BOM/Route		Hardwa	re	L	Over/Under	tolerance	Temperature/Cure
[Cracks		I	Broken/Damaged		Inspecti	on Incomplete		Part Incorre	—	Weld
	Crushed/	Crimped.		Burrs		Instruct	ions Incomplete/Unclear		Part Lost/Mi	ssing	Wrong Stock Pulled
ſ	Cuffs			Contamination		Mainte	enance		Part Moved		

Mislabeled

Out of Calibration

Out of Sequence

Outside Dimensions

Misread

Offset

Positioned Wrong

Power Loss/Surge

Other

H:/FORMS/Quality Assurance\approved QA/NCRWO Rev G

Turning Sequence

Wave/Twist in Tube

Ripples in Bend

Heat Treat

Inspection Strip in Tube

Torque Waves in Extrusion

Countersink

Cut Too Short

Drill Holes

Drawing

Finish

Folio

Work Orde November-27-12				*938	385*						Page 3
Item ID: Revision ID: Item Name: Start Date: Required Date:	D2933-2 Saddle RH Ir 12/03/12 12/14/12	n, 206 Start Qty: 6.00 Req'd Qty: 6.00	*6* *6*	Accept	*N9000 Cust Item II Customer:		100)*	Setup	Start Stop	*NS1* *NS2*
Reference: Approvals:	Process Pl	an:	Date:	Tooling:	Da				Run	Start Stop	*NR1* *NR2*
Sequence ID/ Work Center II 160 *160* QC Quality Control	D	Operation Description QC3- Inspect Part Finish Memo		Set Up/ Run Hours 0.00	Tool ID	Tool#	Plan Code	Accept Qty	t Rej Qty		Reject Insp. Number Stamp
170 **170* Packaging Packaging		Identify as per dwg & St Memo	ock Location:	0.00							/3/4/3 E
180 *180* QC Quality Control		QC21- Final Inspection	- Work Order Release	0.00					`	13	14/4 8
1						i				al n	6L1.1/

MB-04-4

J		DQA:	Date:	
NCD. Voc / No	MODE OPDED NON-CONFORMANCE / LIDDATE			

WCN.	103	, 110					0011110		.,		QA Closed:	Date	e:
Work Ord	er:					DISPOSITION				AGAINST DE	PARTMENT,	/PROCESS	
Part I				İ		Rework Scrap		٨	Skid-tube Aachining	Crosstube Small Fab	4	Water Jet	Engineering Quality Quality
NCR I	No.			!		Use-as-is Work Order Update	The		noforming Large Fab	Finishing Composite	Rec/Sto	re/Packaging Supplier	Other
Root					Descri	ption of work order update	Initia	1	Act	tion	Sign &		
Cause		Date	Step	Qty	(or Non-conformance	Chief E	ng	Descr	ription	Date	Verification	QC Inspector
Doc/Data				,							-		
Equip/Tooling								1					
Operator	Ш												
Material	Ш		1										
Setup					!								
Other	Ш							Ì					
Process	Ш			'									
Supplier	Ш			İ				- 1					
Training	Ш			'				1					
Unapproved				<u> </u>						<u></u>			
				· · · · · · · · · · · · · · · · · · ·			AULT CA	TEG	<u> </u>				
Landi	$\overline{}$	1		,		General				_	1	Г	- .
	Ш	Bending				Bend	Grai				Ovalized	-	Pressure/Forced
	Ш	Centre No	ot Concer	ntric to	o/s _	BOM/Route	Hard			<u> </u>	Over/Under	<u> -</u>	Temperature/Cure
	\vdash	Cracks				Broken/Damaged	\mathbf{H}		on Incomplete		Part Incorre		Weld
	-	Crushed/	Crimped.			Burrs			ions Incomplete/l	Unclear	Part Lost/M		Wrong Stock Pulled
	\vdash	Cuffs				Contamination	1		nance		Part Moved		
	\vdash	Heat Trea			<u> </u>	Countersink	Misla			<u> </u>	Positioned V		\neg
	-	Inspection		Tube		Cut Too Short	Misr			L.	Power Loss/	/Surge	Other
	Ш	Ripples in		ı	·	Drill Holes	Offse						
		Torque W		xtrusio	n _	Drawing	-		Calibration				
	1	Turning S	equence	ļ		Finish	Out	of S	equence				

Outside Dimensions

Wave/Twist in Tube

Folio

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Picklist Print

November-27-12 2:39:42 PM

Work Order ID:

93885

Parent Item:

D2933-2

Parent Item Name:

Saddle RH In, 206

Comments:

IPP: B00.06.26New DWG rev (mpp 2069)EC

IPP Rev:C As per Rev C 07-03-19 JLM

Start	Date:	12/03/12

Required Date: 12/14/12

Start Qty: 6.00

Required Qty: 6.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure		Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D6101-001		Manufactured	No			100	Each	117.0000	1	6			
Saddle Billet				Location		Loc Qty	Lo	c Code	- <u></u> -2-				
				MAT040		106		į					
				6967	7	2		i					
				7683	6	1		i					
				8192	3	1		!					
				9123	5	30		i			•		
				9123	6	60		1					
•				9259	5	12		1					
				MAT042		1							
				8330	9	1		1					
				MAT045		10							
				9255	0	10							

B97239 X 6 NOT PULLED

one 13/03/29

			DQA:	Date:	
/ 61	t.	MODE ODDED MON CONFORMANCE / HDD ATE			

NCN. I	es / W	J	.		WORK ORDER NOR-		IVIAINCE / OF	DAIL	QA Closed:	Date	::
Work Orde	ar.		:		DISPOSITION			AGAINST DE	PARTMENT	/PROCESS	Ì
Part N	-				Rework Scrap]	Skid-tube Machining	Crosstube Small Fab	Pro	Water Jet	Engineering Quality
NCR N	lo				Use-as-is Work Order Update	Ther	moforming Large Fab	Finishing Composite	Rec/Sto	re/Packaging Supplier	Other
Root				Descri	ption of work order update	Initial	Ac	ction	Sign &		
Cause	Date	Step	Qty		or Non-conformance	Chief En	Desc	cription	Date	Verification	QC Inspector
Doc/Data											·
quip/Tooling											
Operator											
Material [•	i	1				
etup									1		
Other			i							i	
Process											
Supplier											
[raining											
Jnapproved											
			1		F.	AULT CAT	EGORY				
Landin	ng Gear				General				_		_
	Bendin	g	,		Bend	Grain			Ovalized		Pressure/Forced
	Centre	Not Conce	ntric to	o/s	BOM/Route	Hardw	are		Over/Under	tolerance	Temperature/Cure
	Cracks				Broken/Damaged	Inspec	tion Incomplete		Part Incorre	ct	Weld
	Crushe	d/Crimped	- ,		Burrs	Instruc	tions Incomplete/	/Unclear	Part Lost/M	issing	Wrong Stock Pulled
	Cuffs		-		Contamination	Maint	enance		Part Moved	1	
	Heat T	eat	ļ		Countersink	Mislab	eled		Positioned V	Wrong	
[Inspect	ion Strip in	Tube		Cut Too Short	Misrea	nd		Power Loss/	[/] Surge	Other
[Ripples	in Bend	I		Drill Holes	Offset					
	Torque	Waves in I	Extrusio	n 「	Drawing	Out of	Calibration				
	Turning	g Sequence			Finish	Out of	Sequence				
	Wave/	Twist in Tul	be		Folio	Outsid	e Dimensions	•			

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DART AEROSPACE LTD	Work Order:	93885
Description: 206 Saddle, Inboard, Right side	Part Number:	D2933-2
Inspection Dwg: D2933 Rev. C		Page 1 of 1

Inspect dimensions highlighted on inspection sheet drawing D2933 Rev. C and record below:

				Re	corded Actu	ıal Dimensi	ons		
Dim	Min	Max	Go/No Go Gauge	1	2	3	4	Ву	Date
Α	0.100	0.140		123	.123	.123	.123		
В	0.100	0.140		.123	.122	.122	122		
С	0.100	0.140		123	.122	.122	.121		
D	0.210	0.230		-222	222	222	222		***
E	1.245	1.255		1.250	1.250	1.250	1,257		
F	1.245	1.255		1.250	1,250	1.257	1.257		· · · · · ·
G	2.495	2.505		2,500	2.500	2.500	2.500		
Н	0.510	0.515		512	,572	.572	-72		_
Ī	1.572	1.582		1.577	1577	1522	1527		
J	2.495	2.505		2.500	2500	2.500	2.500		
K	0.257	0.262		258	.258	.252	,258		
L	0.312	0.317		312	.312	.312	.3/2		
M	0.235	0.240		240	,2395	240	.234		
N	0.100	0.140		122	122	122	122		100
0	0.540	0.560		508	.549	cug	.549		-
Р	0.490	0.510		.502	.503	.503	.502		
Q	3.715	3.725		3.720	3.720	3.720	3.720		
R	2.470	2.510		2490	2.490	2.490	2.490		
S	0.240	0.270		252	.251	.251	.251		
T	0.100	0.180		14/2	140	141	1210		
Ū	1.625	1.635		1. 2.30	1.230	1.2.30	1.630	-	
V	1.362	1.372		1.368	1318	1310	1.3/2		-
W	0.316	0.321		.3/2	21/2	311	3/10		
X	1.125	1.145		1.136	113%	1136	1.136		
Υ.	1.565	1.585	DT8695 A/B	1.573	1572	1.571	1.573		<u> </u>
Z	0.178	0.198		.188	188	.188	.188		
AA				1.730	-/-00	-/05	00		
AB									
AC								-	-,,
AD					 				
AE				,	-				
AF								- +	
AG	<u> </u>							+	
AH	-	<u> </u>						-	
	Acc	ept/Reje	ct			<u> </u>			

Measured by: Onl	Audited by F.K.
Date: 13/03/29	Date** (3/03/30

Rev	Date	Change	Revised by	Approved
Α		New issue	R.F.	
В	02.12.12	Re-format; Added Dim. X-Y, DT8683, DT8686, DT8690 & DT8695 A/B	KJ/RF	1
С	07.03.21	Revised per drawing revision C	KJ/JLM ox	all.

DART AEROSPACE LTD	Work Order:	-93888
Description: 206 Saddle, Inboard, Right side	Part Number:	D2933-2
Inspection Dwg: D2933 Rev. C		Page 1 of 1

Inspect dimensions highlighted on inspection sheet drawing D2933 Rev. C and record below:

				Recorded Actual Dimensions					
Dim	Min	Max	Go/No Go Gauge	15	26	3	4	Ву	Date
Α	0.100	0.140		.123	.122				
В	0.100	0.140		.122	. 122				
С	0.100	0.140		1.123	.123				
D	0.210	0.230		.221	,221				
E	1.245	1.255		1.250	1,250				
F	1.245	1.255		1.250	1,250				
G	2.495	2.505		2.50n	2.500				
Н	0.510	0.515		575	.512				
I	1.572	1.582		1.577	1.577				
J	2.495	2.505		2.500	2.500				-
K	0.257	0.262		.258	,258				
·L	0.312	0.317		.3/2	.312				,
M	0.235	0.240		.240	.239				
N	0.100	0.140		.121	.121				
0	0.540	0.560		,550	549				
P	0.490	0.510		.503	.500				
Q	3.715	3.725		3.721	3.720				···
R	2.470	2.510		2.490	2.490				
S	0.240	0.270		,251	.251				
T	0.100	0.180		.140	./4/				
U	1.625	1.635		1.1.30	1.630				
V	1.362	1.372		1.327	1.367			1	
W	0.316	0.321		.3/2	.3/2				
Х	1.125	1.145		1.131	1.135		*		
Υ	1.565	1.585	DT8695 A/B	1.573	1.573				
Z	0.178	0.198		.188	.188				
AA									
AB					<u>-</u>				
AC									•
AD									
ΑĒ					-				-0"
AF		-							· · · · · · · · · · · · · · · · · · ·
AG									
АН								1	
	Acc	ept/Reje	ct					1	

Measured by:	one	Audited by
Date:	13/03/29	Date: 13/04/04
	· · · · · · · · · · · · · · · · · · ·	

_Rev	Date	Change	Revised by	Approved
Α		New Issue	RF	
В	02.12.12	Re-format; Added Dim. X-Y, DT8683, DT8686, DT8690 & DT8695 A/B	KJ/RF	- 1
С	07.03.21	Revised per drawing revision C	KJ/JLM ax	Sul

